Date:

Sunday, 12/4/2005 12:45:11 PM

Liser

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 25089C

Estimate Number

: 10354

P.O. Number

: NIA

This Issue

: 12/4/2005

S.O. No. : N/A

: NC : NIA : 24533C

Part Number Drawing Number Project Number

Material

Due Date

Drawing Name

: D2322 D2322 REV C

: N/A

; C **Drawing Revision**

: NIA : 12/12/2005

: STEP SPACER

29 Um:

Each

Previous Run Written By

Prsht Rev.

First Issue

Checked & Approved By

COMMENT BELOW COMMENT BELOW

Comment

New Issue 05-11-07 JLM : Est Rev:A

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M2024T3S040

2024-T3 .040 sheet

Comment: Qty.:

0.2132 sf(s)/Unit Total: 4.2630 sf(s)

Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick

(M2024T3S.040) Identify as D2322 Batch: <u>M19059</u>

2.0

SHEAR

SHEAR J.L.

Comment: SHEAR

Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500")

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1 TL

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2322, use stack of 15

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

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Date: Sunday, 12/4/2005 12:45:12 PM User: Linda Lacelle **Process Sheet Drawing Name: STEP SPACER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 25089C Part Number: D2322 Job Number: Seq. #: Description: Machine Or Operation: SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr NC BRAKE BRAKE NC 7.0 Comment: NC BRAKE Form as per Dwg D2322 INSPECT WORK TO CURRENT STEP QC5 8.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 9.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT PACKAGING RESOURCE #1 11.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 37 DOCUMENT/CONTROL 12.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

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DART AEROSPACE LTD	Work Order:	
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.005	.247				
4.178	+/-0.005	4.177	<i>J</i> .			
4.428	+/-0.010	4.427	1			
0.250	+/-0.005	-250				
6.520	+/-0.010	6.521	1			
Ø0.128	+0.005/-0.000	.130	J,			
R0.125	+/-0.010	. 125				
				.3		
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Measured by:	Audited by:	m	Prototype Approval:	N/A
Date: 05.12.11	Date:	05/12/11	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.10.12	New Issue P/O D2	582	KJ/JLM	

